CLAIMS

1. A method of making a reclosable bag, comprising the steps of:

supplying a continuous web of bag-forming material in a first direction to a bag-forming station;

attaching to the continuous web a plurality of zipper strips at intervals spaced in the first direction and extending transversely of the web, each zipper strip comprising first and second interengagable profiles pre-assembled into a least partial engagement with each other;

forming end-sealed bags at the bag-forming station, each bag having opposed first and second walls, at least one of which is formed from the said continuous web of material, first and second end seals, and therebetween at least one of the zipper strips attached to a respective wall of the bag; and

treating the bags adjacent the respective zipper strip profiles in order to secure the profiles to the first and second walls respectively and to form an openable and reclosable seal inside the bags.

2. A method according to claim 1, in which the zipper strips are initially attached to the continuous web only sufficiently to hold them in position, final securement taking place in the said step of treating the bags.

3. A method according to claim 1 or 2, in which the step of treating the bags takes place after the web has been separated into individual bags.

4. A method according to claim 3, in which the treating step takes place at a securement station, prior to which the bags are reorientated so that they are fed to the securement station with their zipper strips aligned along a common axis.

5. A method according to claim 4, in which the common axis is transverse to the direction of supply of the continuous web.

6. A method according to any preceding claim, in which the bags are treated by the application of heat and/or pressure to secure the zipper-strip profiles to the bags.

7. A method according to any preceding claim, wherein the bags are treated by a belt sealer.

8. A method according to any preceding claim, wherein the direction of supply of the continuous web is substantially horizontal and the common axis is substantially horizontal.

9. A method according to any of claims 1 to 7, wherein the direction of supply of the continuous web is substantially vertical and the common axis is substantially horizontal.

10. An apparatus for making a reclosable bag, the apparatus comprising successively:

means for attaching to the continuous web a plurality of zipper strips at intervals spaced in the first direction and extending transversely of the web, each zipper strip comprising first and second interengagable profiles pre-assembled into a least partial engagement with each other;

a bag-forming station at which are formed bags having opposed first and second walls, at least one of which is formed from the continuous web of material, first and second end seals and therebetween and attached to a respective wall of the bag at least one of the zipper strips; and

means for treating the bags adjacent the respective zipper strip profiles to secure the profiles to the first and second walls respectively and to form an openable and reclosable seal inside the bags.

11. An apparatus according to claim 10, comprising means located between the bag-forming station and the treatment means for separating the continuous web into individual bags.

12. An apparatus according to claim 11, comprising means located between the separating means and the treatment means for reorientating the separated bags so that their respective zipper strips are aligned one with another along a common axis.

13. An apparatus according to any of claims 10, 11 or 12, in which the common axis is transverse to the direction of supply of the continuous web.

14. An apparatus according to claim 11, 12 or 13, in which the treatment means comprises means for conveying the bags through a treatment zone where the bags are treated to secure the zipper-strip profiles to the walls of the bags.

15. An apparatus according to claim 14, in which the conveying means engage the zipper-strip profiles, whilst making contact with the respective outer surfaces of the walls of the bags.

16. An apparatus according to claim 15, in which the conveying means effect the treatment to secure the profiles to the bag walls.

17. An apparatus according to claim 16, in which the conveying means comprise a belt sealer.

18. An apparatus according to any of claims 10 to 17, in which the means for treating the bags apply heat and/or pressure to secure the zipper-strip profiles to the bags.

19. An apparatus according to any of claims 10 to 18, wherein the direction of supply of the continuous web is substantially horizontal and the common axis is substantially horizontal.

20. An apparatus according to any of claims 10 to 18, wherein the direction of supply of the continuous web is substantially vertical and the common axis is substantially horizontal.

21. A method of making a reclosable bag, the method being substantially as hereinbefore described with reference to the drawings.

22. A reclosable bag made by a method according to any of the claims 1 to 9 and 21.

23. A reclosable bag substantially as hereinbefore described with reference to the drawings.